

Date: Thursday, 05/02/2009 3:44:46 PM
User: Julie Dawson

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : HELI ACESS STEP RH |
| Job Number : 45547 | |
| Estimate Number : 11764 | |
| P.O. Number : | Part Number : D206628022BL |
| This Issue : 05/02/2009 S.O. No. : | Drawing Number : N/A - BLUE |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : |
| Previous Run : 43490 | Material : |
| Written By : | Due Date : 10/03/2009 Qty: 2 Um: Each |
| Checked & Approved By : <u>JLD 0902-04</u> | |
| Comment : Est Rev:D as per ECN 766 JLM | |
| Est Rev:E as per ecn 1118 DD verified by:EC | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-022 CHG 002 003



(PTC)

| | | |
|-----|-------------|-----------------------|
| 2.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Pick Packing Kit



| | | |
|-----|--------|-------------------------|
| 3.0 | 45547A | 206L /407 STEP ASSY, RH |
|-----|--------|-------------------------|



Comment: Sub-Component Step Assembly

1 x D2724-042 Batch 45547A



| | | |
|-----|----------|----------------|
| 4.0 | D2732030 | Rubber Cushion |
|-----|----------|----------------|



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s) (3.1)

Rubber Cushion
batch 38509



88 09/06/16 (2)

| | | |
|-----|-------|------------------|
| 4.1 | D2732 | Rubber Extrusion |
|-----|-------|------------------|



Comment: Qty.: 1.0000 f(s)/Unit Total : 2.0000 f(s)
Rubber Extrusion



N/A

(PTC)

| W/O: 45547 | | EST: 11764 | | WORK ORDER CHANGES | | | | | |
|------------|------------|--|-----------|---------------------------------|-----|------------------------------------|--------------------------------|--|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng/ Prod Mgr | Approval QC Inspector | | |
| 09/06/17 | 4.0 4.1 | Adcl the correct P/W for the 3" length of Rubber, & remove 4.1 D2732 (not necessary) <i>per m. change</i> | <i>HD</i> | 09/06/18 <i>ALREADY DONE</i> | | <i>[Signature]</i> 05/06/17 | <i>[Signature]</i> 05/06/17 | | |
| 09/06/17 | 1.0 | I.P.P now at chg 003. <i>Perm. Change</i> | | | | <i>[Signature]</i> 05/06/17 | <i>[Signature]</i> 05/06/17 | | |

Part No: D206-628-022BL PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|-------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH

Job Number: 45547

Part Number: D206628022BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

✓ AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch

M110372

6.0

✓ D27317

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 BLUE Mounting Lug

43389

7.0

✓ D3394043

Lug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 BLUE LUG ASS.Y

43388

8.0

✓ AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN4-15A Bolt

M110399

9.0

✓ AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN960JD416 Washer

M110279

10.0

✓ MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21042L4 Nut (or MS21042-4)

M110507

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 05/02/2009 3:44:46 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP RH

Job Number: 45547

Part Number: D206628022BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

09/06/17 (2) RH

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-022

Location:

PPP Rev:

4

9/4/17

5250

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/18 JF

Job Completion



MF
09-06-17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

| Qty -011 | Qty -012 | Qty -021 | Qty -022 | Qty -031 | Qty -032 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|--------------|-------------------------------------|
| X | | | | | | D206-628-011 | 206 A/B STEP INSTALLATION LH |
| | X | | | | | D206-628-012 | 206 A/B STEP INSTALLATION RH |
| | | X | | | | D206-628-021 | 206 L/L1/L3/L4 STEP INSTALLATION LH |
| | | | X | | | D206-628-022 | 206 L/L1/L3/L4 STEP INSTALLATION RH |
| | | | | X | | D206-628-031 | 407 STEP INSTALLATION LH |
| | | | | | X | D206-628-032 | 407 STEP INSTALLATION RH |
| 1 | | | | | | D2721-041 | STEP ASSEMBLY LH |
| | 1 | | | | | D2721-042 | STEP ASSEMBLY RH |
| | | 1 | | 1 | | D2724-041 | STEP ASSEMBLY LH |
| | | | 1 | | 1 | D2724-042 | STEP ASSEMBLY RH |
| 2 | 2 | | | 4 | 4 | D2731-3 | MOUNTING LUG |
| 2 | 2 | 4 | 4 | | | D2731-7 | MOUNTING LUG |
| 8 | 8 | 8 | 8 | 8 | 8 | D2732-030 | RUBBER CUSHION |
| 2 | 2 | | | 4 | 4 | D3394-041 | MOUNTING LUG |
| 2 | 2 | | | 4 | 4 | *D3394-1 | *MOUNTING LUG |
| 4 | 4 | | | 8 | 8 | *MS35489-93 | *GROMMET |
| 2 | 2 | 4 | 4 | | | D3394-043 | MOUNTING LUG |
| 2 | 2 | 4 | 4 | | | *D3394-3 | *MOUNTING LUG |
| 4 | 4 | 8 | 8 | | | *MS35489-93 | *GROMMET |
| 4 | 4 | | | 4 | 4 | AN4-13A | BOLT |
| 4 | 4 | 4 | 4 | 4 | 4 | AN4-14A | BOLT |
| 4 | 4 | 8 | 8 | 4 | 4 | AN4-15A | BOLT |
| 12 | 12 | 12 | 12 | 12 | 12 | AN960JD416 | WASHER |
| 12 | 12 | 12 | 12 | 12 | 12 | MS21042L4 | NUT (OR MS21042-4) |

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

REFERENCE ONLY

45547